

# Work Order ID 60165

June 28, 2010 11:50:26 AM



Page 1

Item ID: D4133-041

Accept



Setup Start



Revision ID:

Item Name: Wearplate, Mid

Stop



Start Date: 6/29/10 Start Qty: 2.00

Cust Item ID:

Required Date: 7/15/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *R*

Date: *10/6/29* Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4133

A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4133

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

*Deburr = 7 m-l w/06/29 (2x)*

*B 10-6-29*

*(2)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*B 10-6-29*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*8/10/06/30*

*(x2)*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

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Page 2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Form as per dwg  
NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1- Form using DT Die as per Dwg D4133

SB 10/6/20

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Chris/David  
to first set

10.07.14

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:  
OVEN TEMPERATURE:  
FINISH TIME:

8:05  
320°  
8:35

2 10-7-15.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 60165

June 28, 2010 11:50:27 AM

Page 3

Item ID: D4133-041

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Revision ID:

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Start Date: 6/29/10 Start Qty: 2.00

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept Reject Reject Insp.  
Qty Qty Number Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

170

0.00

Small Fab

Memo

0.00

Small Fab

1- Bond D4133-3 gasket to inner surface of wearplate using a thin layer of 3M  
1300/1300L scotch grip adhesive  
Batch: M113174

180

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Y2

(2X)

W/07/15

18 10.07.15 (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 60165

June 28, 2010 11:50:28 AM

Page 4

Item ID: D4133-041

Accept

Revision ID:

Item Name: Wearplate, Mid

Start Date: 6/29/10 Start Qty: 2.00

Required Date: 7/15/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Cust Item ID:

Customer:



Setup Start



Stop



Run Start



Stop

10/7/16 (2)

10-7-16

MF

10-7-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

June 28, 2010 11:50:26 AM

Page 1

Work Order ID: 60165

Parent Item: D4133-041

Parent Item Name: Wearplate, Mid





Start Date: 6/29/10

Required Date: 7/15/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4133-3 		Manufactured	No			200	Each	0.0000	1	2			
Gasket M304S18GA 		Purchased	No			100	sf	132.8779	2.735	5.757895			
304/316 .050 Sheet													



B60306

2x

M/L w/07/15

10-6-29

Location	Loc Qty	Loc Code
MAT20	132.8779	
111743	8.86	
112885	28.0179	
113062	96	

113062

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

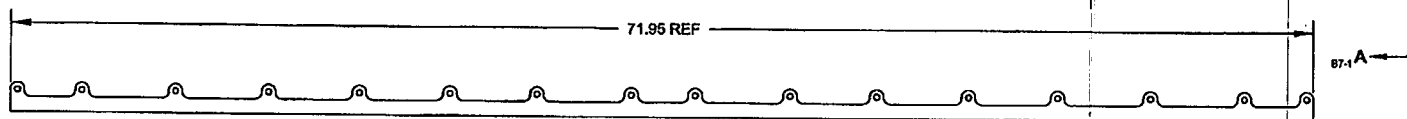
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

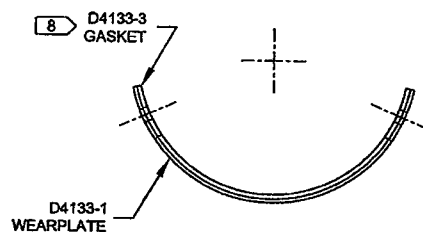
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**NOTE:** Date & initial all entries

QTY	PART NUMBER	DESCRIPTION
-041		
X	D4133-041	WEARPLATE, MID
1	D4133-1	WEARPLATE
1	D4133-3	GASKET
A/R	1300 / 1300L	3M SCOTCH-GRIP ADHESIVE



**D4133-041 WEARPLATE, MID**



**VIEW A-A**  
SCALE 4X

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *60165*  
*BS 10629*

**RELEASED**  
2010-06-23

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4133-041" USING YELLOW PAINT MARKER ON INSIDE SURFACE
- 7) WEIGHT: 4.9 lbs
- 8) BOND D4133-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

A NEW ISSUE		CP 10.06.15	
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>92</i>		
DRAWN	<i>92</i>		
CHECKED	<i>1</i>		
MFG. APPR.	<i>1</i>		
APPROVED	<i>1</i>		
DE APPR.	<i>1</i>		
DATE	10.06.15		

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA  
DRAWING NO. D4133  
TITLE WEARPLATE, MID  
REV. A  
SHEET 1 OF 4  
SCALE NTS

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

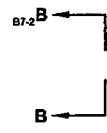
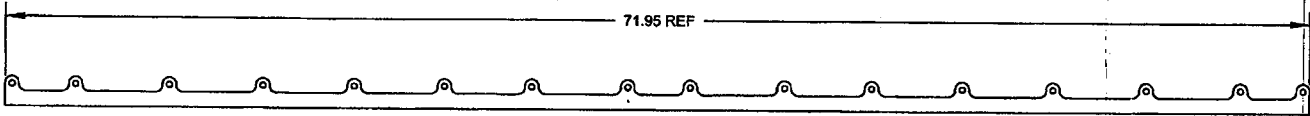
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

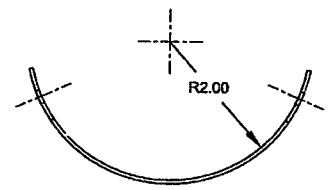
D



C

C

**D4133-1 WEARPLATE**



C1-2 **VIEW B-B**  
SCALE 4X

B

B

*W/L 60165*

**RELEASED**  
2010-06-23

**NOTES:**

- 1) MATERIAL: MAKE FROM D4133-1F
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.0 lbs

A

A

DESIGN	99	<b>DART AEROSPACE USA, INC</b>	
DRAWN	99	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4133	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE, MID	NTS
DATE	10.06.15	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL, AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

**Dart Aerospace Ltd**

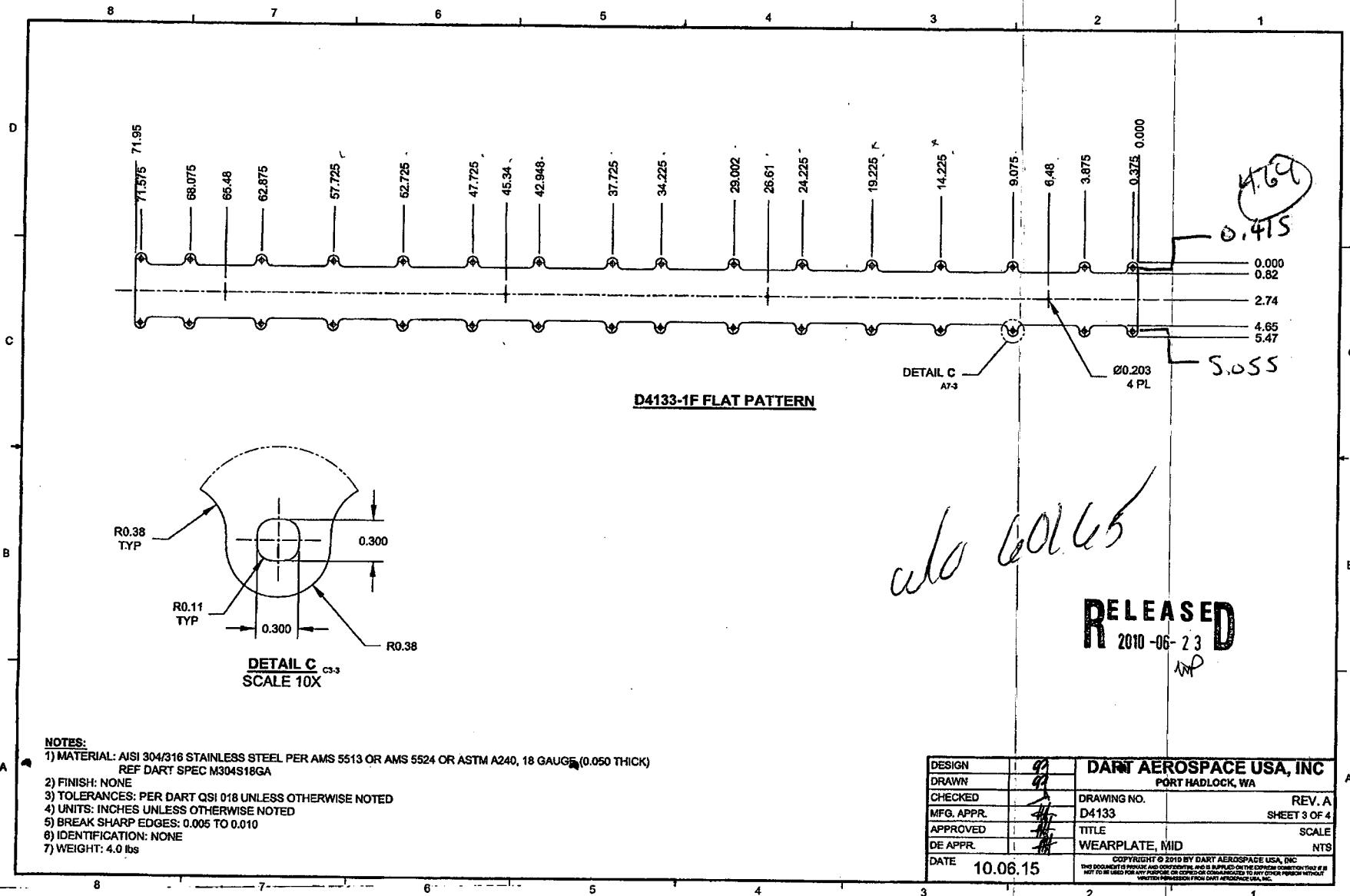
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Dart Aerospace Ltd**

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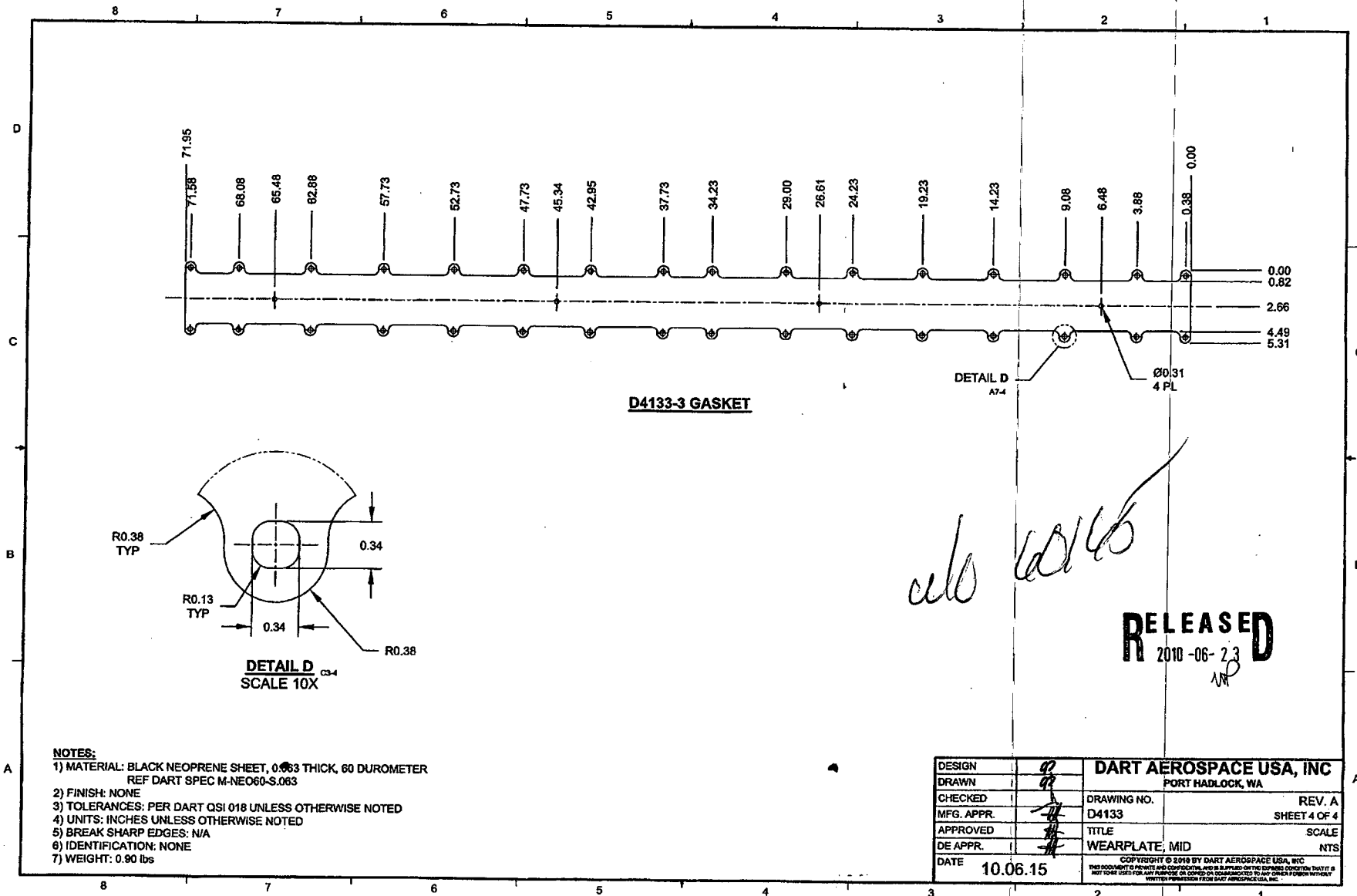
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DRAWN	92	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4133	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE, MID	NTS
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DART AEROSPACE LTD		Work Order: 60165
Description: WEAR PLATE MID.		Part Number: D4133-041
Inspection Dwg: D4133-1 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.300	±.010	.301	✓			
.300	±.010	.301	✓			
.82	±.030	.817	✓			
2.74	±.030	2.733	✓			
4.65	±.030	4.641	✓			
5.47	±.030	5.475	✓			
φ .203	+ .005 - .001	.203	✓			
.375	±.010	.373	✓			
3.875	±.010	3.875	✓			
6.48	±.030	6.48	✓			
9.075	±.010	9.075	✓			
14.225	±.010	14.225	✓			
19.225	±.010	19.225	✓			
24.225	±.010	24.225	✓			
26.61	±.030	26.61	✓			
29.000	±.010	29.000	✓			
34.225	±.010	34.225	✓			
37.725	±.010	37.725	✓			
42.948	±.010	42.948	✓			
45.34	±.030	45.34	✓			
47.725	±.010	47.725	✓			
52.725	±.010	52.725	✓			
57.725	±.010	57.725	✓			

Measured by: DB	Audited by: S	Prototype Approval: N/A
Date: 10-6-29	Date: 10/6/30	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

